

Work Order ID 163375

Tuesday, June 27, 2017 11:34:28 AM

163375

Page 1

Item ID: D4956-23

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Center Fwd

Start Date: 6/29/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/6/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUL 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4956	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: 4Prog Rev: 4

2-Deburr if necessary

1.09

⑥ SC 17/07/04 DAS
19
9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.06

⑥ SC 17/07/04 DAS
19
9-89

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Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center Fwd
Start Date: 6/29/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/6/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				<u>60</u>			DAS 38 9-89 JUL 04 2017
130 *130* Brake NC Brake NC	Form as per dwg Memo FORM JOGGLE AS DWG	0.28 0.56				<u>6</u>	<u>8</u>		JUL 10 2017 DAS 19 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>60</u>			DAS 38 9-89 JUL 10 2017

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Packaging

DAS
41
9-89

DAS
38
9-89

JUL 13 2011

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.60							
Quality Control									



JUL 13 2017

Picklist Print

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Work Order ID: 163375

163375

Parent Item: D4956-23

D4956-23

Parent Item Name: Wearplate Center Fwd

Start Date: 6/29/2017

Required Date: 7/6/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	114.2600	1.25	7.894737			
M304S20GA									**			sc 17/07/04	
304/316 .040 Sheet													

Location

Loc Qty

Loc Code

MAT020

114.26

m136327

3.15

m136568

3.78

m137263

2.5

m137362

5.73

m137513

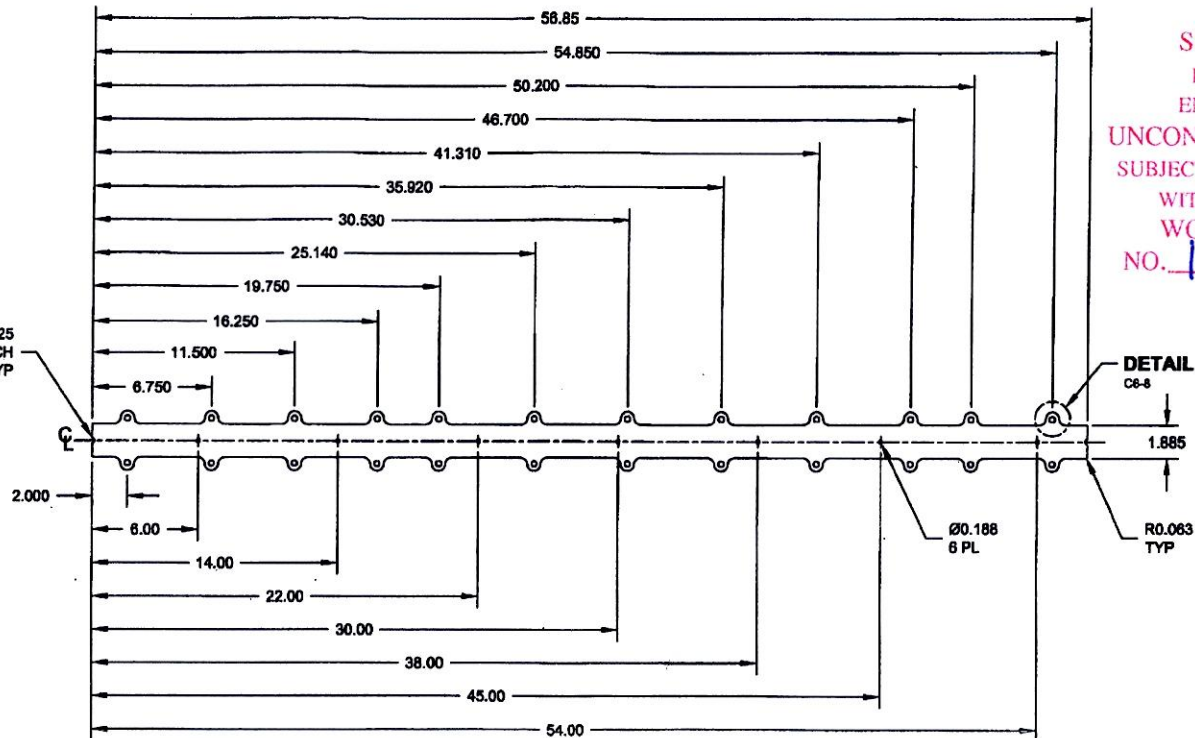
35.1

m137762

64

8

R0.25
TOOLING NOTCH
TYP



D4956-23F FLAT PATTERN



D4956-23 WEARSHOE
(MAKE FROM D4956-23F)

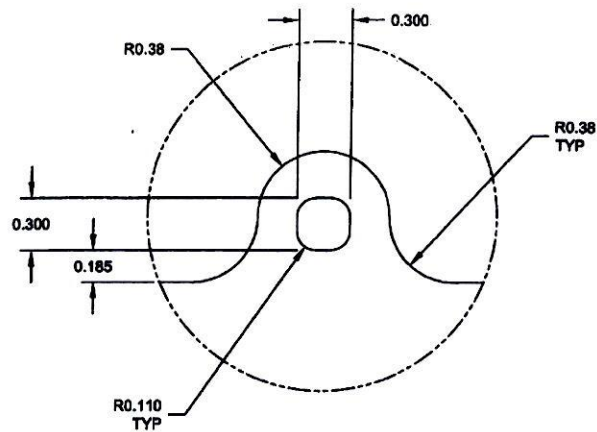
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163375 M5
170703

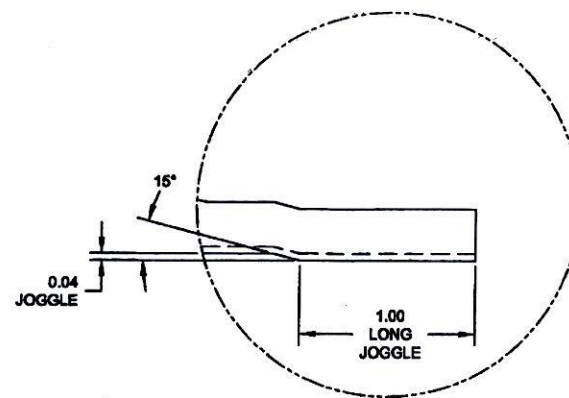
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2014-04-17
MP

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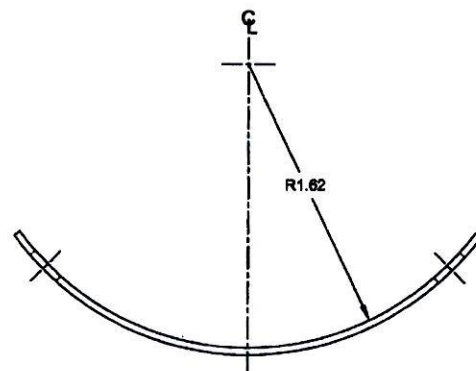
DETAIL A

C8-1	C4-1
C8-2	
C8-3	C1-3
C2-4	
C8-5	C2-6
C8-6	C2-6
C4-7	C3-7



DETAIL B

B6-1	B2-1
B3-2	
B5-3	B1-3
B2-4	
B4-7	B1-7



SECTION C-C

B7-1	B3-1
B5-2	
B7-3	B3-3
B8-4	
B7-5	B3-5
B7-6	B3-6
B7-7	B3-7

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